

SPLIT-1

Work Order ID 64783-1



Friday, December 17, 2010 7:53:10 AM

Page 1

Item ID: D3910-3

Accept



Setup Start



Revision ID:

Item Name: Crosstube Lug

Stop



Start Date: 12/16/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: *PL*

Date: *10-2-17*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3910

B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut to 1.450" Long

cut extension @ meter

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA865 AND DWG

FOLIO REV:

DWG REV:

DEBURR

issue 710, 13326 to meter

machine as per dwg D3910 REV. B

CL 11/01/20 (18) 30

CL 11/01/27 (18)

Purchasing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC 2K
Quality Control

QC2 - Inspect parts off machine FAI/FAIB

0.00

rec'd + inspect for transit damage

Memo

0.00

CY 11/16/12 18

130



QC
Quality Control

QC Inspect parts - second check

0.00

Memo

0.00

11-01-27 18

140



HandFinish
Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

18 11-01-27

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

START 3:30
QWENT. 8:30
FINISH 11:00

0.00

Powder Coating

18 BR 11-06-27.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/1/28 SP 18X

170

Identify as per dwg & Stock Location: 507

0.00



Packaging

Memo

0.00

Packaging

11/1/28 SP 18X

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/31
ME

11-01-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Friday, December 17, 2010 7:53:14 AM

Page 1

Work Order ID: 64783

Parent Item: D3910-3

Parent Item Name: Crosstube Lug



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423 Lug Extrusion		Manufactured	No			100	f	550.0314	0.13	2.189474 3.9			



CL 11/10/120

Location

Loc Qty

Loc Code

MAT06

550.0314265

43722

180

45800

82.0314265

63005

288

~~2.19~~ 3.9

D3910-3P

X 30

CL 11/10/127 X18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

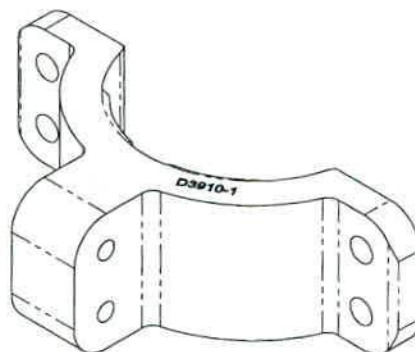
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

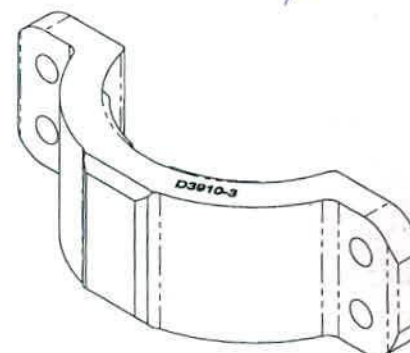
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STANDARD
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44783
25-12-17



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG

RELEASED
2010-03-22
MP

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS
OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs

B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3); REASON: SEE TR-D350-507-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3910 SHEET 1 OF 3
TITLE SCALE
X-TUBE LUG (350) NTS

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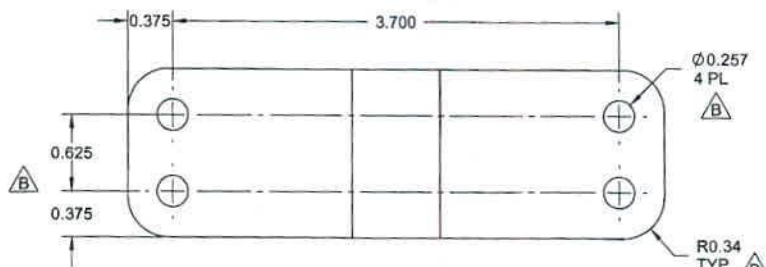
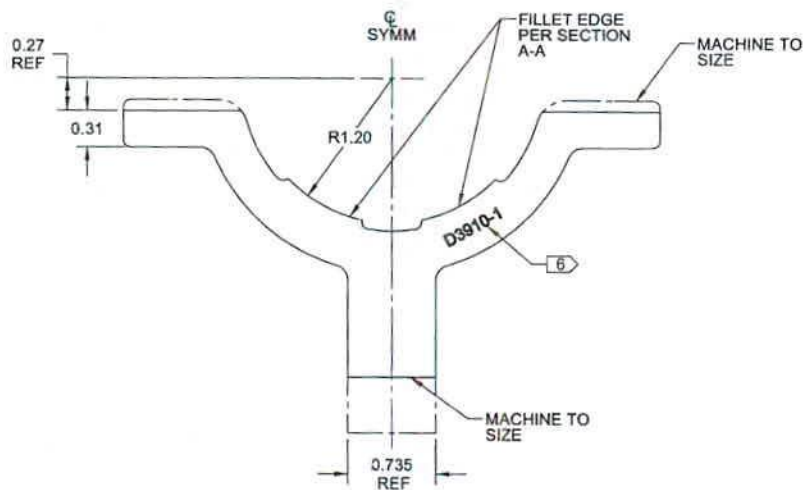
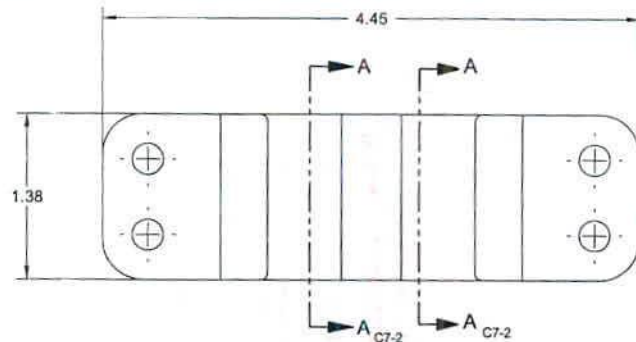
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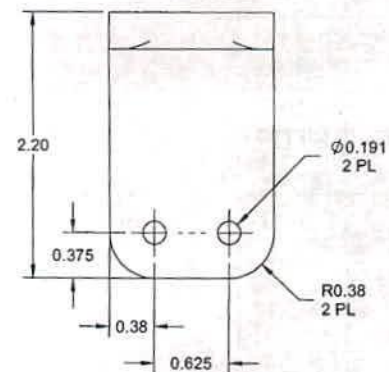


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A
C4-2
C5-2



D3910-1 X-TUBE LUG



RELEASED
2010-03-22
WP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SHEET 2 OF 3
DE APPR.	<i>[Signature]</i>	SCALE NTS	
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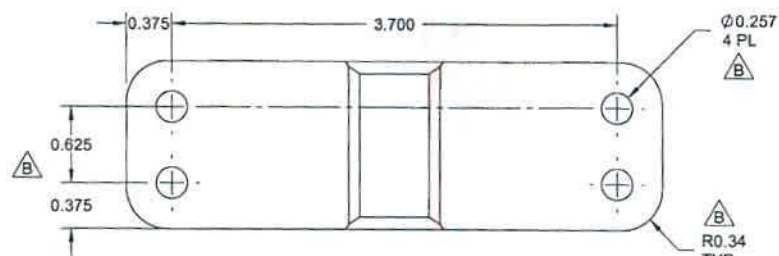
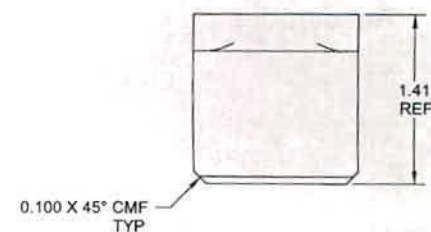
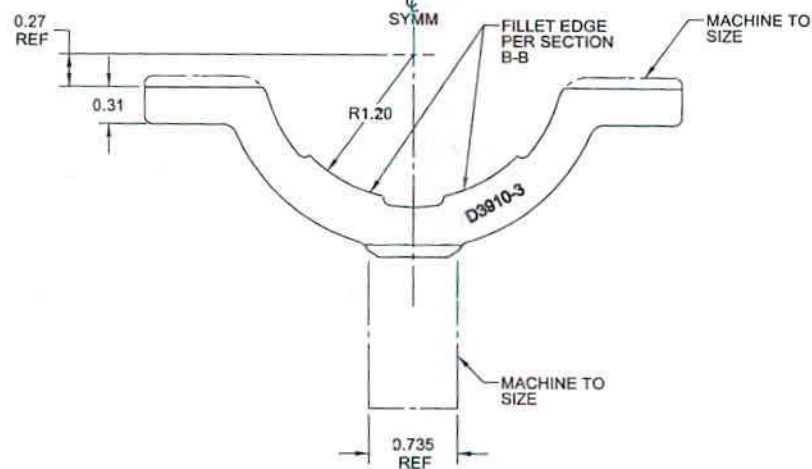
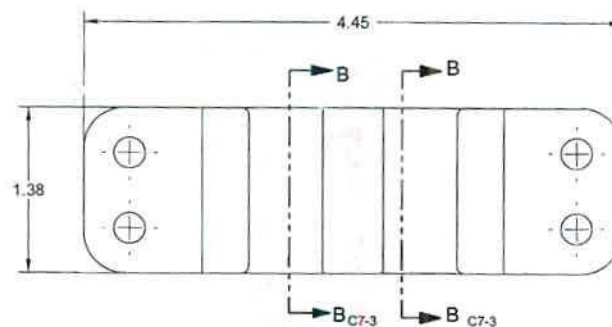
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ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B
C4-3
C5-3



D3910-3 X-TUBE LUG

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3910	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
18	D3910-3	Crosstube Lug	13326

MATERIAL: supplied by DART D2423 B45800 ✓

CL110127

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Fabian Kueffer

Vankleek Hill, January 27, 2011

20 Terry Fox Drive P.O. Box 781 • Vankleek Hill ON K0B 1R0 • (613) 678-3957 Fax: (613) 678-3956